



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200
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D3294-1
Job Sheet 187238



Part No: D3294-1

Job Qty: 40 ea

Part Name: Bracket For Interior Window For -115



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP A 04.08.24 New issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	12/13/18	12/13/18	0.00	3.21	Waterjet - Flow		DE 19/03/01
110	QC	10 pcs	12/13/18	12/13/18	0.00	0.00	QC2 Waterjet-1		DE 19/03/01
120	QC	10 pcs	12/13/18	12/13/18	0.00	0.00	QC8-2		SC 19/03/04
130	Brake NC	10 pcs	12/13/18	12/13/18	0.08	1.38	Brake NC 1		58 MAR 07 2019
140	QC	10 pcs	12/13/18	12/13/18	0.00	0.00	QC5		D.R 19/03/07
150	HandFinish	10 pcs	12/13/18	12/13/18	0.00	0.76	HandFinish1		36 DAS
160	QC	10 pcs	12/13/18	12/13/18	0.00	0.00	QC7-2		40 DAS
170	Small Fab	10 pcs	12/13/18	12/13/18	0.00	1.57	Small Fab-3		9-89
180	QC	10 pcs	12/13/18	12/13/18	0.00	0.00	QC5		40 DAS
190	Powdercoat	10 pcs	12/13/18	12/13/18	0.00	0.44	Powdercoat4		9-03
200	QC	10 pcs	12/13/18	12/13/18	0.00	0.00	QC3		40 DAS
210	Packaging	10 pcs	12/13/18	12/13/18	0.00	0.00	Packaging3-1		40 DAS
220	QC21-SA	10 Ea	12/13/18	12/13/18	0.00	0.00	QC21		9-89

Part Op 100 - 1-Cut as per Dwg D3294 CUT File D3294-3 Dwg Rev: D Prog Rev: D *grain direction on a 45 deg as

Descriptions: per dwg** 2-Deburr if necessary

130 - 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)

170 - 1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

190 - Start Time: 9:55 Oven Temperature: 320° Finish Time: 10:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	18 sf (1.8 ea)	100-Waterjet - Flow - 1	
D3294-5	Doubler	10 Ea (1 ea)	170-Small Fab	5071119
MS20470AD4-5	Rivet, Universal Head	150 Ea (15 ea)	170-Small Fab	5049829-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	18	71	0
170-Small Fab	D3294-5	10	10	0
	MS20470AD4-5	150	761	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Part Specifications

Specifications could not be found.

Plex 11/29/18 9:57 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

DART AEROSPACE LTD		Work Order: 187238
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.128	1		U.D.-02	
Ø0.141	+0.005/-0.001	0.140	1		T-J	
6.708	+/-0.010	6.705	1			
1.118	+/-0.010	1.117	1			
5.590	+/-0.010	5.593	1			
1.118	+/-0.010	1.119	1			
13.563	+/-0.010	13.563	1			
1.043	+/-0.010	1.041	1			
0.625	+/-0.010	0.624	1			
0.325	+/-0.010	0.326	1			
0.300	+/-0.010	0.301	1			
0.400	+/-0.010	0.402	1			
6.000	+/-0.010	5.999	1			
1.000	+/-0.010	0.999	1			
17.124	+/-0.010	17.124	1			
16.13	+/-0.030	16.13	1			
7.27	+/-0.030	7.27	1			
11.97	+/-0.030	11.97	1			
8.37	+/-0.030	8.37	1			
20.05	+/-0.030	20.05	1			
12.98	+/-0.030	12.98	1			
14.59	+/-0.030	14.59	1			
11.66	+/-0.030	11.66	1			
0.080	+/-0.010	0.080	1			

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 19/03/01	Date: 19/03/04	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	[Signature]



Container No: S158323



Part: D3294-1

Job No: 187238

Serial No/Batch: S158323

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 03/01/19